



## NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:

- A) CIMCOOL 5 STAR 49  
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10<sup>-10</sup> STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS

ALCATEL SAM-110TCL  
Du PONT CEC 24-120B  
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [ ] ARE MILLIMETERS

## REF. SOURCES

2 STANDARD BELLOWS CO.  
375 TUNPIKE AVE.  
WINDSOR LOCKS, CONN. 06096

1 MDC VACUUM PRODUCTS CORP.  
23842 CABOT BLVD.  
HAYWARD, CA. 94545-1651



3	ST'D. BELLOWS CAT. #750 - 600 - 5 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100031	8" CF. ROTATABLE FLANGE	1
1	MDC'C CAT. #110033	10" CF. NONROTATABLE FLANGE	1

ITEM	SYM/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
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## PARTS LIST

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES. THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

LOG NUMBER V2910000-01

DESIGNED BY MUSCIA DATE 7/6/99 CHECKED BY D. SHU DATE 7/6/99

DESIGNER SHU/MUSCIA DATE 7/6/99 PROJECT MGR T.M. KUZAY DATE 7/6/99

RESPONSIBLE ENGINEER D. SHU DATE 7/6/99 APPROVED/RELEASED

MATERIAL SCALE 1:1 SHEET 1 of 1

DRIVING NUMBER V2-910000-01

1	V2910000-01 WAS A14770			
	V2-910000-01 WAS			
	410509702-910000-00			
	(NEW LOG # & PART #)			
	.000 [152.40] WAS .000 [101.60]	M.J.M.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			